



## DUAL CARBIDE TIPPED UNDERBODY SNOW PLOW BLADES MGS-01-02B

**1.0 DESCRIPTION.** This specification covers dual tipped carbide underbody snowplow blades.

### **2.0 MATERIALS.**

**2.1 Steel.** The blades shall be fabricated from flat hot rolled carbon steel meeting the requirements of either ASTM 576-90b or ASTM 575-89 with the range of Grades SAE 1020 or equal.

**2.2 Tungsten Carbide Inserts.** The inserts shall be a high shock WC Grade of tungsten carbide.

**2.2.1** The inserts shall meet Virgin Tungsten Carbide quality specifications and shall meet the following requirements.

#### **2.2.1.1 Face Insert Characteristics:**

Specification	Requirement
Cobalt Content, percent	19.0 – 21.0
Density, g/cm <sup>3</sup> (ASTM B 311)	13.25 - 13.65
Hardness (ASTM B 294, Rockwell A Scale)	83.5 - 85.0
Transverse Rupture Strength, psi, min.	330,000

#### **2.2.1.2 Center Insert Characteristics:**

Specification	Requirement
Cobalt Content, percent	10.5 - 12.5
Density, g/cm <sup>3</sup> (ASTM B 311)	14.1 - 14.6
Hardness (ASTM B 294, Rockwell A Scale)	87.5 - 89.0
Transverse Rupture Strength, psi, min.	350,000

**2.2.2** The insert shall be rectangular and trapezoid design with the following dimensions for each:

#### **2.2.2.1 Face Insert Dimensions:**

Specification	Requirement
Height, inch	0.745 ± 0.005
Width, inch	0.310 ± 0.010
Length, inch, nominal	2

#### **2.2.2.2 Center Insert Dimensions:**

Specification	Requirement
Height, inch, long side	0.635 ± 0.005
Width, inch	0.365 ± 0.010
Length, inch, nominal	1
Bottom Angle	25 degrees with a nose radius of 1/16-inch minimum.

## **2.3 Finished Blades.**

**2.3.1 Insert Placement.** The groove for the carbide inserts shall be milled on the blade edge. The tungsten carbide inserts shall be positioned in the milled area with approximately 0.010-inch space between the inserts the entire length of each cutting edge section. Each of the inserts shall be one-inch nominal length for the center inserts and two-inch nominal length for the face inserts. It may be necessary for some of the inserts to be different than the nominal lengths to make up for the spacing between the inserts. The number of one-inch inserts shall be no less than one or more than three from the number required for one insert per inch of blade length. The number of two-inch inserts shall be no less than one or more than two from the number required for one insert per two inches of blade length.

**2.3.2 Brazing.** The inserts shall be brazed on all contact surfaces consistent with sound brazing practice with no evidence of voids or use of shims. Brazing shall be of such strength and quality as required to prevent movement or loss of the inserts during use.

**2.3.3 Physical Requirements.** All blades shall be straight and free from flaws and injurious defects, and shall have workmanlike finish.

**2.3.3.1** The finished blade sections shall be free of warpage and longitudinal deviation shall not exceed 1/8 inch in a four-foot or five-foot long blade section or 3/32 inch in a three-foot long blade section. The edge that rests upon the pavement shall be straight and true. The longitudinal warp and the alignment of this edge shall be measured by extending a straight edge from one end of the blade to the other and measuring from the straight edge to the blade at the mid-point of length.

**2.3.3.2** The difference between the highest and lowest tip point shall not exceed 1/32 inch on any given blade assembly.

**2.3.3.3** Punching shall be 11/16 inch square holes with 1 5/32 inch diameter countersink 3/8 inch deep to receive either 5/8 inch or 3/4 inch diameter plow bolts as required. Location of holes shall be in accordance with AASHTO standards for "heavy-duty" punching. Details, location, and spacing of the holes shall be as shown on the attached drawing for a standard state highway three-, four- or five-foot blade.

**2.3.3.4** Moldboards are punched with holes 1/8 inch larger than the blade bolts. Accordingly, blade punching will be of such accuracy, both for the spacing between holes and for the spacing between the end hole and the end of the blade, that the blades will fit the moldboards, thus making the blade sections interchangeable.

**2.3.4** The paint used to coat the blades shall be dry prior to shipment and shall not smear or track during handling.

## **3.0 CERTIFICATION AND ACCEPTANCE.**

**3.1** Prior to approval and use of any material delivered, the manufacturer shall submit to the State Project Operations Engineer, P.O. Box 270, Jefferson City, Missouri 65102, a certification in triplicate certifying the grade of steel used in fabricating the blade and certifying that the blades supplied conform to all requirements and specifications.

**3.1.1** The "Certification Statement" form shown in Section 5.0 is to be used when certifying. The certification shall include or have attached specific results of test performed on the tungsten

carbide inserts for cobalt content, density, hardness and transverse rupture strength and showing the standard test designation of the test specified for each of these properties. The certification shall show the purchase order number, destination, quantity of material represented at each destination and shipping date.

**3.2** Acceptance of the blades and carbide tip inserts shall be based on the manufacturer's certification and upon the results of such tests as may be performed on samples of the material. When samples are taken, one complete blade of each length shall be taken to represent the shipment. A shipment will be considered as all blades represented on one certification and shipped on one date, regardless of various destinations. The carbide tip inserts shall be sampled from the blades selected for testing.

**3.2.1** If a blade fails to meet any of the specified requirements, two additional blades will be selected for retest from the same quantity represented by that certification. Both of these retest samples must meet all requirements or the entire quantity will be rejected.

**3.2.2** If the carbide tip inserts fail to meet any of the specified requirements, two additional samples will be selected either from the original blade sampled or from other blades contained in the same quantity represented by that certification. Both of these retest samples must meet all requirements or the entire quantity will be rejected.

**3.2.3** If the blades are rejected, no payment will be made and the cost of blades destroyed during sampling and testing shall be borne by the supplier.

#### **4.0 TEST METHOD MODOT T21 DETERMINATION OF COBALT IN TUNGSTEN CARBIDE INSERTS.**

##### **4.1 Scope**

**4.1.1** This method describes a procedure for determining the percent of Cobalt in Tungsten Carbide Inserts used in Snow Plow Blades, using Atomic Absorption Spectrophotometry.

##### **4.2 Equipment and Reagents**

**4.2.1** An Atomic Absorption Spectrophotometer.

**4.2.2** Hydrofluoric Acid (HF), 48 percent

**4.2.3** Nitric Acid (HNO<sub>3</sub>), specific gravity 1.42

**4.2.4** Hydrochloric Acid (HCl), specific gravity 1.19

**4.2.5** Distilled Water

##### **4.3 Preparation of Standards**

**4.3.1** 1000 ppm Cobalt stock solution: This solution can be purchased from a number of sources, or it can be prepared in the laboratory from a suitably pure Cobalt salt.

**4.3.2** 8.00% Cobalt standard solution: Place approximately 250 mL distilled water into a 1000 mL volumetric flask. Add 10 mL HF, 5 mL HNO<sub>3</sub>, and 20 mL HCl. Pipette 20.00 mL of 1000 ppm Cobalt stock solution into the flask and dilute to volume with 1:99 HCl prepared with distilled water. This solution is equivalent to 8.00% cobalt.

**4.3.3** 16.00% Cobalt standard solution: Place approximately 250 mL distilled water into a 1000 mL volumetric flask. Add 10 mL HF, 5 mL HNO<sub>3</sub>, and 20 mL HCl. Pipette 40.00 mL of 1000 ppm Cobalt stock solution into the flask and dilute to volume with 1:99 HCl prepared with distilled water. This solution is equivalent to 16.00% cobalt.

**4.3.4** Blank solution: Prepare a blank by the same procedure used to prepare the 16.00% Cobalt standard, omitting the addition of 40.00 mL of Cobalt stock solution.

#### **4.4 Procedure**

**4.4.1** Crush or grind an insert until approximately 4-5 grams will pass a No. 50 sieve. Weigh, to 0.1 mg, 0.2500 grams of the material passing the No. 50 sieve, and place in a platinum crucible having a volume of 25-35 mL. Add 10 mL of HF and 2 or 3 drops of HNO<sub>3</sub>. Cover the crucible immediately and heat gently. Add 2 or 3 drops of HNO<sub>3</sub> each time the reaction subsides, keeping the crucible covered as much as possible. When solution of the sample is complete, remove the cover, rinse it with H<sub>2</sub>O, and cool to room temperature. Place approximately 100 mL of distilled H<sub>2</sub>O in a 400 mL beaker and quantitatively transfer the solution into the beaker. Rinse the crucible 4-5 times with distilled H<sub>2</sub>O, once with 1:99 HCl, and finally with distilled H<sub>2</sub>O. Add 20 mL HCl to the contents of the beaker and dilute to approximately 250 mL with distilled H<sub>2</sub>O. Cover with a watch glass, boil vigorously about 5 minutes, digest 3 hours at low heat, and let precipitate overnight. Filter on Whatman No. 42 paper into a 1000 mL volumetric flask, washing 10-12 times with hot 1:99 HCl. Cool and dilute to volume with 1:99 HCl. (Note: For inserts with higher concentrations of cobalt, the dilution should be increased to allow for the cobalt concentration to fall within the prepared standard solution range.)

**4.4.2** Calibrate the instrument using the blank solution, the 8.00% standard solution and the 16.00% standard solution, then determine the concentration of the sample solution.

#### **4.5 Calculation and Report**

**4.5.1** The method of calculating the percent Cobalt in the sample will vary with the make and model of instrument used. Report the Cobalt in the sample to the nearest 0.1% as follows:

% Cobalt (Co)

## 5.0 CERTIFICATION STATEMENT.

### CERTIFICATION STATEMENT DUAL CARBIDE TIPPED UNDERBODY SNOWPLOW BLADES

State Project Operations Engineer  
P. O. Box 270  
Jefferson City, MO 65102

Dear Sir:

We hereby certify that the dual carbide tipped underbody snowplow blades described below comply with all requirements of Specification [MGS-01-02](#) and in accordance with bid request No. \_\_\_\_\_.

The following blades manufactured by \_\_\_\_\_ are covered by this certification.

Purchase Order No.	Destination	Quantity & Size	Shipping Date

Following are results of tests performed on these blades:

Grade of Steel in the Blade: \_\_\_\_\_

Cobalt Content in Carbide Tip: \_\_\_\_\_ Test Method: \_\_\_\_\_

Density of Carbide Tip: \_\_\_\_\_ Test Method: \_\_\_\_\_

Hardness of Carbide Tip: \_\_\_\_\_ Test Method: \_\_\_\_\_

Transverse Rupture Strength: \_\_\_\_\_ Test Method: \_\_\_\_\_

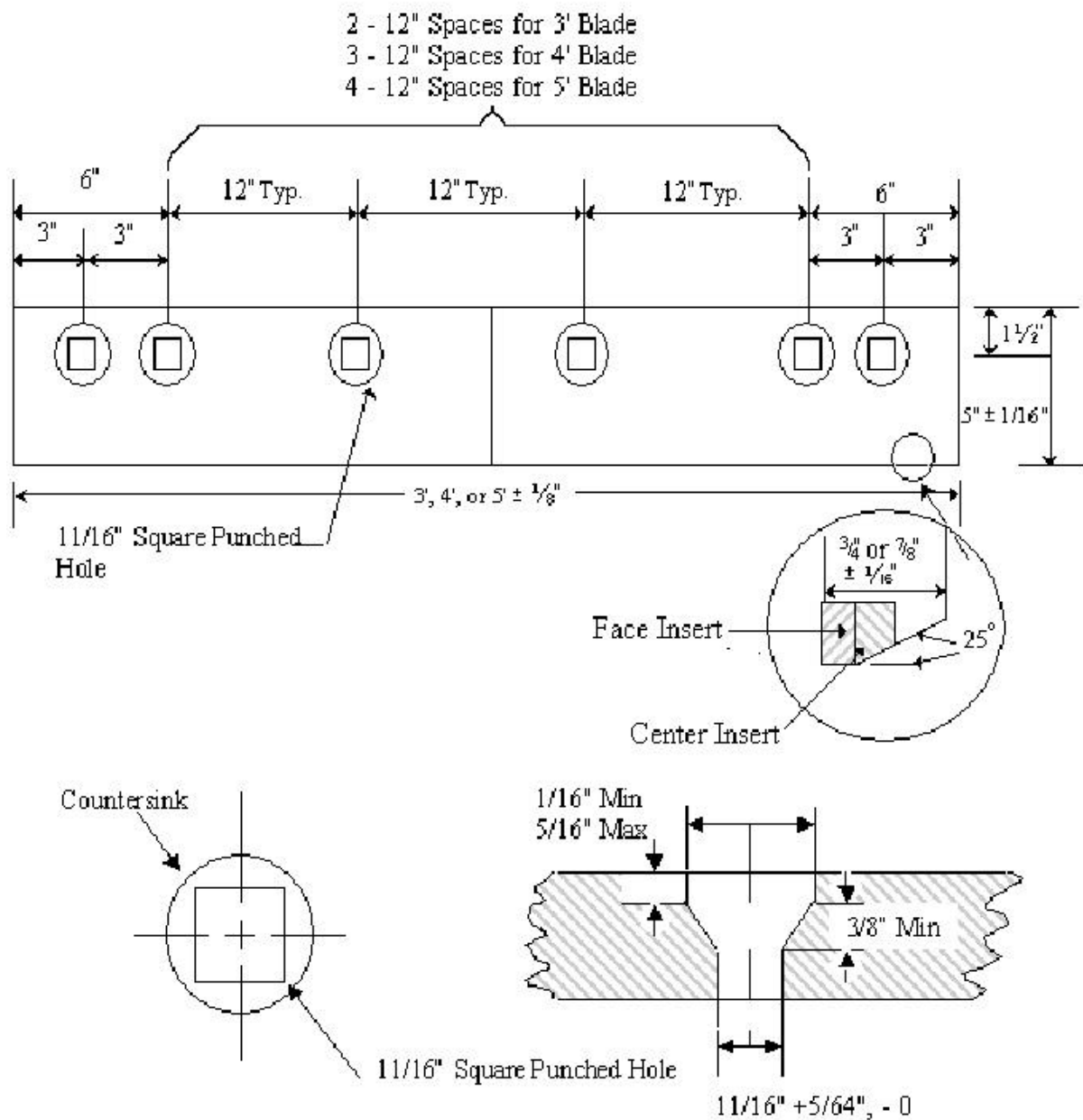
Certified By: \_\_\_\_\_

Title: \_\_\_\_\_

Date: \_\_\_\_\_

Results of tests may be shown on attachments rather than on this form, if preferred.

This form is to be completed, signed, and submitted in triplicate for each shipment, at the same time as blades are shipped. A shipment is defined as all blades represented on one certification and shipped on one date, regardless of various destinations.



NOTE: This drawing not to scale.

## Plan of Dual Carbide Tipped Snowplow Blades